

Work Order ID 74306

Wednesday, September 28, 2011 11:32:15 A



Rush

Item ID: D4093-3

Accept



Setup Start



Revision ID: ,

Stop



Item Name: Bracket

Start Date: 9/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *M.L.J*

Date: *9/29/11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4093

C

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS DWG

6561 750 X 8 1/2

DWG REV: *C*

PROG REV: *C*

DEBURR

B11-10-11

(10)

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74306

Page 2

Wednesday, September 28, 2011 11:32:15 A

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Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>A</i> 11/10/12		10			
132 Small Fab Small Fab	Memo DRILL AS PER DWG	0.00 0.00		<i>A</i> 11/10/12		10			
135 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>S</i> 11/10/13		<i>(10)</i>			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 74306

Wednesday, September 28, 2011 11:32:15 A

Page 3

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Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 9/28/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/13/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BR 11-10-13

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3 Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

n/a 11-10-11

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10X Ø m-f 11/10/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 74306

Wednesday, September 28, 2011 11:32:15 A

Page 4

Item ID: D4093-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 9/28/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/13/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location 139

0.00



Packaging

Memo

0.00

Packaging

11/14/13 10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/17
ME 11-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 11:32:12 AM

Page 1

Work Order ID: 74306



Parent Item: D4093-3



Parent Item Name: Bracket

Start Date: 9/28/2011

Required Date: 10/13/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD IPP
REV:B AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X08.00

Purchased

No

f

12.0000

10.52632

0



6061-T6 BAR .750" X 8.00"



10-10-11

Location

Loc Qty

Loc Code

MAT003

12

117085

12

6061 .750x 6

-12567

12567

(10)

6.00
10-10-11
JLM

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74306
Description: BRACKET	Part Number: D4093-3
Inspection Dwg: D4093-3, Rev: C	Page 1 of 1

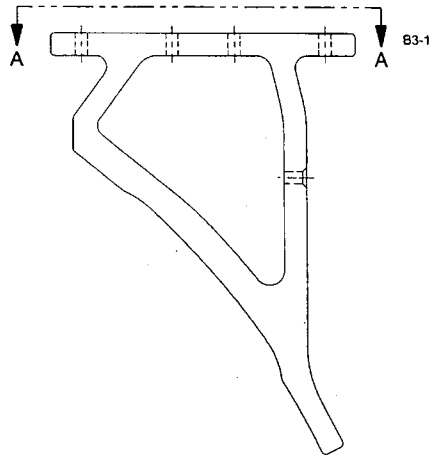
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.05	$\pm .030$	1.047	✓		V B02	
3.85	$\pm .030$	3.847	✓		V	
5.03	$\pm .030$	5.023	✓		V	
.38	$\pm .030$.385	✓		V	
.50	$\pm .030$.513	✓		V	
4.82	$\pm .030$	4.807	✓		V	
1.79	$\pm .030$	1.79	✓		V	
.38	$\pm .030$.395	✓		V	
.31	$\pm .030$.313	✓		V	
4.20	$\pm .030$	4.210	✓		V	
7.03	$\pm .030$	7.022	✓		V	
.750	$\pm .030$.742	✓		V	
.38	$\pm .030$.370	✓		V	
.201	$\pm .004$.202	—		RA26	✓
.500	$\pm .010$.503	—		"	
1.500	$\pm .010$	1.503	—		"	
2.530	$\pm .010$	2.535	—		"	
1.500	$\pm .010$	1.501	—		"	

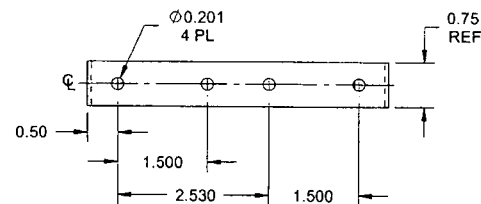
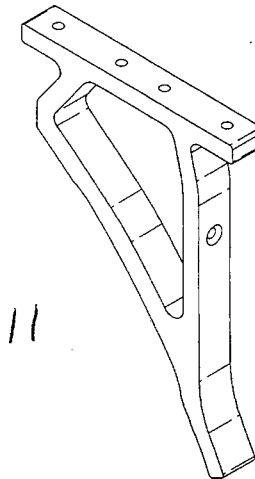
Measured by: RB	Audited by:	Prototype Approval:
Date: 11-10-11 11/10/12	Date: 11/10/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74306

M.C.J.
9/29/11



SECTION VIEW A-A D6-1

RELEASED
2011-09-22

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.54 lbs

D4093-1 BRACKET

C	REDRAWN D4093-1/3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-1/3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. C
MFG. APPR.	141	D4093	SHEET 1 OF 5
APPROVED	142	TITLE	SCALE
DE APPR.	143	BRACKET	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

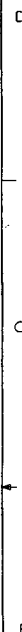
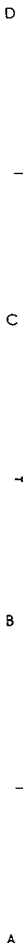
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2



△C

22
(M)

A horizontal number line with tick marks labeled 8, 7, 6, 5, 4, 3, 2 from left to right. A point is marked on the line between 4 and 5, closer to 5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

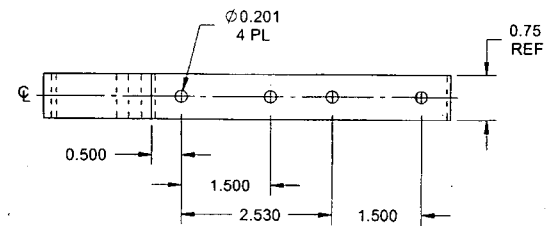
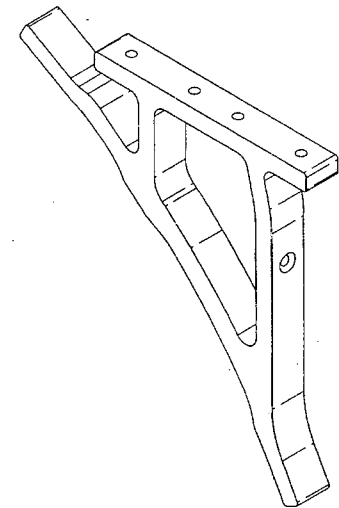
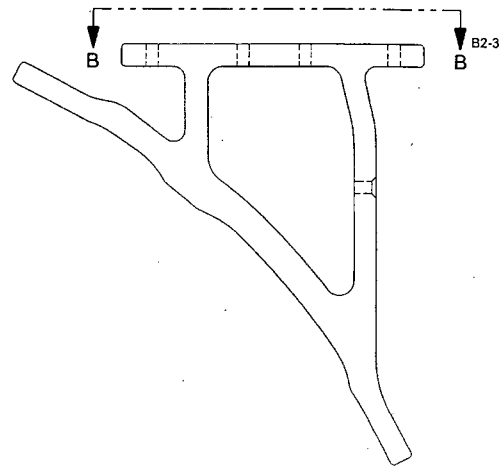
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74306



D4093-3 BRACKET

SECTION VIEW B-B B5-3

RELEASED
2011-09-22

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.63 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RF</i>	D4093	SHEET 3 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

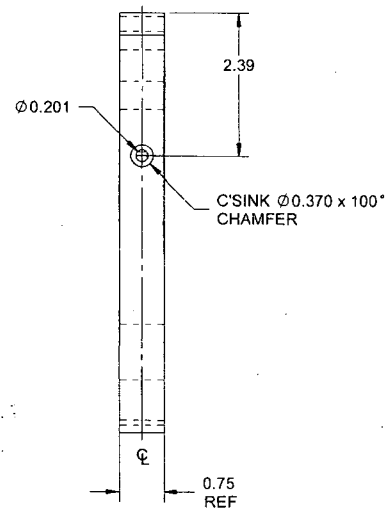
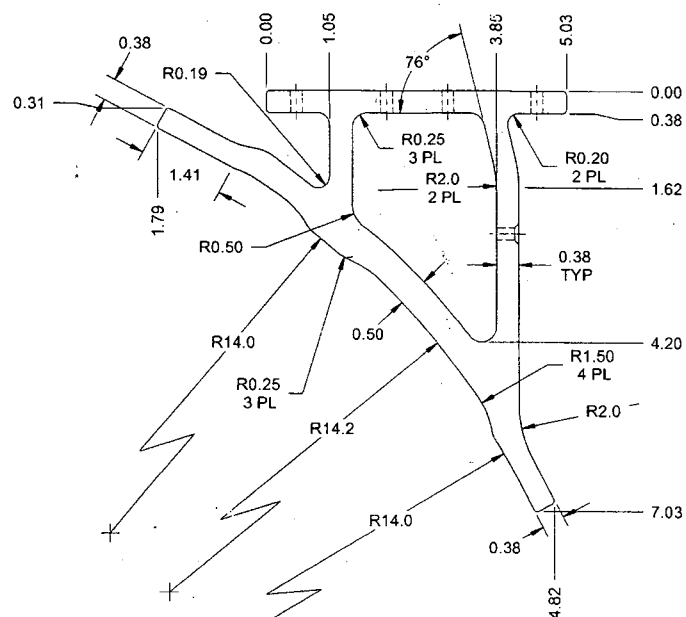
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74306



D4093-3 BRACKET

RELEASED
2011-09-22
MD

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	MD	DRAWING NO.	REV. C
MFG. APPR.	MD	D4093	SHEET 4 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BRACKET	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

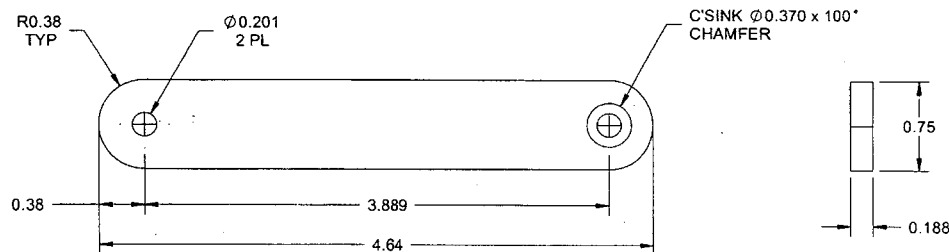
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74306

**D4093-5 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 OR 6061-T6/T62 ALUMINUM SHEET
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED
 2011-09-22
 JAW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>AD</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AD</i>	D4093	SHEET 5 OF 5
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	BRACKET	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries